

used in 37300

Dart Aerospace Ltd.

Date: Monday, 11/12/2007 10:51:37 AM
User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP EXTRUSION
Job Number	: 35618		
Estimate Number	: 10058		
P.O. Number	: N/A	Part Number	: D2622120C
This Issue	: 11/12/2007 S.O. No. : N/A	Drawing Number	: D2622 REV C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C1
Previous Run	: 34694	Material	: N/A
Written By	:	Due Date	: 11/30/2007
Checked & Approved By	:	Qty:	110 Um: Each
Comment	: Est. A: [Signature] ew Issue KJ/RF		

Additional Product

Job Number

St

Description :

PURCHASING



Cc

2013

C207/10/12

as per Dwg D2622 Rev. C

Material: 6061-T6 (QQ-A-200/8)

c) Minimum yield tensile strength = 35 ksi

d) Minimum ultimate tensile strength = 38 ksi

e) Minimum elongation = 8%

f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A

h) To be packed per DSK 066

i) Pull test to ASTM standard B221 required.

j) Material certification is required

2.0 D2622120CP

Extrusion

Comment: Qty.: 1.0000 Each(s)/Unit Total : 110.0000 Each(s)
Extrusion

3.0 PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material certification is attached

4.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2622

Check Pull test per Dwg D2622 for compliance page attached

Check hardness with Webster tester

C 211/12 B (132)
S 41u127 (+132)



BON L CANADA INC
 500 EDWARD AVENUE
 RICHMOND HILL, ON L4C 4Y9

CERTIFICATE OF COMPLIANCE

Cart Date	Cart No	Sales Order	Page
11/23/07	169640	14251	1
Cart No	S/L No	Lot	Date
5013	00365098	14251010	11/23/07

Ship To	Ship To
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Part No	Part No	Item Description	Cart Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622
Gross Weight	571 KGS		
Net Qty	547 KG	132 PC	402 M 2 PKG
Specification	Bin Desc		
AMS-QQ-A-200/8 & ASTM B221-00			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	307.6 / 44.6	277.3 / 40.2	10.5	.0	96

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.66	.24	.28	.07	.92	.07	.006	.06	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

OK
 08.02.11

D. VanBakel, QA Manager Signed for Bon L Canada

D3731

m6061T65125 m105646

Receiving Report

Date:

07/09/14

Supplier:

Canada

Packing Slip:

Yes ☒ No ☒

Invoice:

Yes ☒ No ☒

Receipt:

Cash ☒ Cr ☒

Batch No:

14105646

Dart P/O:

4562

Release Note Attached:

Yes ☒ No ☒

Waybill Attached:

Yes ☒ No ☒

Shipment Complete:

Yes ☒ No ☒QC6 Inspection *En*

Work Order

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

07/09/14

Date
Received/Costing
InitialBTP 5690
12

Location

H:\FORMS\Purchasing\approved purchase\RECREPORT Rev D

4248
5696MONTREAL : 514 336-4248
FAX : 514 336-4246DISTRIBUTEUR D'ACIER ET METAUX SPECIALISES
STEEL AND SPECIALTY METALS DISTRIBUTORONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

On a du Savoir "FER"

SHIP TO:

SEP 24 2007

CE LTD
N STREETFACTURE
INVOICE

N° 179912

DATE

14/09/07

BON DE LIVRAISON
PACKING SLIP

N° 126264

DATE DE LIVRAISON
DELIVERY DATE

14/09/07

TERMS / TERMS

NET 30 JOURS

TERR.

2R

REMARQUES / REMARKS

PAGE N°

001

DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
25 48 X 96	171	550.175	CLB	940.80
	236	364.406	CLB	860.00
	1	2.950	UN	2.95

POIDS TOTAL
TOTAL WEIGHT

408.00

Formplus N° 8619

THIS IS THE PROPERTY OF "ACIER CAMPING INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED. NO REFUND OR CREDIT WILL BE GIVEN. ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE. * ANY DEFAULT IN RESPECT WITH ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE FULL CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. * ANY MERCHANDISE RETURNED CANNOT BE RETURNED. * ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE

E CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y M/M J/D

CUSTOMER'S SIGNATURE

DATE

SOUS-TOTAL
SUB TOTAL

1803.75

T.P.S.
G.S.T.

108.23

T.V.Q.
Q.S.T.

0.00

TOTAL

1911.98

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, LA.

May 1961

Kate Young

Morton P. Young
Quality Assurance Manager

66094

E.L. No.

bivolo No.

Alcoa No. 1200

Page 1

2005-03-08

71201

19715

DC#10030-1

P.O. No./Govt. Contract No.

Customer

412215 20041217

INFETRIS-LAVAL

over

Item Description

152054 (U) A/T 6051-
25 COIL SHEET FOR DISTRIBUTORS TOLERANCE

GUARANTEED FOR 54806831, PER

QMS-00-A-250/11 JMS1027 REV M & ASTM209 REV 04 & ASME-SB-

200 REF A99 DIMENSIONAL TOLERANCES P

109 REV ASS DIMENSIONAL TOLERANCES :
 ANETHE 5.2 REV 2003 (NOT MARKED) } LIGHTLY OILED

DBL. SIZES: ID 20 IN COLL. WTS: MAX 7500

LB. PRG MGT: 8000 LB EXPORT PACK QUAN TOL +/-

30 * COB D152054 REV 30 COST BND 05-03-

02 *** N/R 05-03-05 ***

NUM	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Ser1
1	264478	315683	6362	1	PC	
2	264493	315691	6407	1	PC	
			12769	2		

Notes for COR: D152054.30

Notes for COR: D152054.30
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11P. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11P ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.

COR: D152054.30 -Specification Units

Page	Dir	UTS	TYS	ELAD
TG	Long Transv.	KSI	KSI	PCT
		Max		
		Min	42.0	35.0
				10

Chemical Composition	SI	FE	CU	NI	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
----------------------	----	----	----	----	----	----	----	----	------------	-------------	----------

Chemical Composition		Si	Fe	Cu	Mn	Ni	Al	Cr	P	S	REMAIN
Alloy 6061	Max	.8	.7	.40	.15	1.2	.35	.25	.15	.05	.15
	Min	.40		.15		.8	.04				

Lot; 335683 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No. Test	UTS KSI	UTS TSI	ELAD PCT
T6	Long Transv.	2	Max 50.3	45	12.1
			Min 50.2	44.9	12.1

Legris Metals 8/21/2005 8:45 PAGE 003/004 FAX SERVER
PERSON TULL CANADA INC. P.O. - 76-06004 S.O. - 396551

D3736

m6061765125 m105646

Receiving Report

Date:

07/09/14

Batch No:

M105646

Supplier:

Dart P/O:

4562

Packing Slip:

Yes

No

Invoice:

Yes

No

Receipt:

Cash

Cr

Release Note Attached:

Yes

No

Waybill Attached:

Yes

No

Shipment Complete:

Yes

No

QC6 Inspection

OK

No

N/A

N/A

N/A

N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

07/09/14
RCP 3690
CR

Location

H: FORMS/Purchasing approved purch/RECREPORT Rev D

4248
5696MONTREAL : 514 336-4248
FAX : 514 336-4246DISTRIBUTEUR D'ACIER ET METAUX SPECIALISES
STEEL AND SPECIALTY METALS DISTRIBUTORONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

On a du Savoir "FER"

SHIP TO:

SEP 24 2007

CE LTD
N STREETFACTURE
INVOICE

N° 179912

DATE

14/09/07

BON DE LIVRAISON
PACKING SLIP

N° 126264

DATE DE LIVRAISON
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TERMS / TERMS

NET 30 JOURS

TERR.

2R

REMARQUES / REMARKS

PAGE N°

001

DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
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	236	364.406	CLB	860.00
1	1	2.950	UN	2.95
POIDS TOTAL TOTAL WEIGHT				408.00

Formplus N° 8619

IN THE PROPERTY OF "ACIER CAMPI INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED.
S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.
THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY
TH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH
THE ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE
ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE
RETURNED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE

E CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y	M/M	J/D

CUSTOMER'S SIGNATURE

DATE

SOUS-TOTAL
SUB TOTAL

1803.75

T.P.S.
G.S.T.

108.23

T.V.Q.
Q.S.T.

0.00

TOTAL

1911.98

CERTIFIED INSPECTION REPORT

Alcoa Inc.


PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material and the inspection tools and test the mechanical properties shown on the face of this sheet.



Mark J. Yabick
Director of Manufacturing Davenport Works



Nelson P. Young
Quality Assurance Manager

366505

Ship Date

2005-03-08

P.O. No./Gov Contract No.

412215 20041217

66094

B.L. No.

71201

Invoice No.

89715

Customer

INTEGRIS-LAVAL

Alcoa No. Item

ECK10030-1

Page 1

Ship To: INTEGRIS METALS LTD
3399 FRANCIS HUGHES,
LAVAL, PQ, H7L 5A5

Item Description

ALUMINUM 7050 T6 1/2" DIA 152054 (M) A/T 6061-
PC COIL SHEET FOR DISTRIBUTORS TOLERANCE
GUARANTEED 7/8" 54806831. PER
AMS-QQ-A-250/11 & AMS4027 REV N & ASTM209 REV 04 & ASME-SB-
209-REV-209 DIMENSIONAL TOLERANCES ?
ANNE35.2 REV 2003 (NOT MARKED) LIGHTLY OILED
COIL SIZES: ID 20 IN COIL WTS: MAX 7500
LB PRG WGT: 6000 LB EXPORT PACK QUAN TOL +/-
30 % COR D152054 REV 30 CUST REQ 45-03-
02 *** W/E 05-03-05 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	264478	335683	6362	1	PC	
2	264493	335691	6407	1	PC	
			12769	2		

Notes for COR: D152054.30

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11P. PRODUCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11P ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.

COR: D152054.30 -Specification Limits

Temp	Dir	UTS	TTS	ELAD
T6	Long Transv.	Max	ESI	PCT
		Min	42.0	35.6 10

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Each	Total	Aluminum
Alloy 6061	Max	.8	.7	.40	.15	1.2	.35	.25	.15	.05	.15
	Min	.40		.15		.8	.04				REMAIN

Lot: 335683 -Mechanical, Physical, Metallurgy, Quantometer Results

Temp	Dir	No.	UTS	TTS	ELAD
T6	Long Transv.	Test	ESI	ESI	PCT
		Max	50.3	45	12.1
		Min	50.2	44.9	12.1

INTEGRIS Metals 6/21/2005 6:45 PAGE 003/004 FAX Server
ALCOA TULL CANADA INC. P.O. - 76-06004 S.O. - 396551